

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015667**Date Inspected:** 13-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. This QA Inspector made the following observations:

OBG Trial Assembly Yard:

OBG Seg 9CE to Seg 9DE:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process of weld joint nos: DP699-001-019, 020 & 021. The welder was identified as 054467. The ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

The SMAW process of weld no's: DP712-001-019, 020 & 021. The welder was identified as 048659. The ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

The SMAW process of weld no's: OBE9C-004 & 005. The welders were identified as 067665 & 067942. The ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2214-B-U2-FCM-1.

OBG Seg 9CW:

This QA Inspector observed ZPMC personnel performing the heat straightening operation on Floor Beam Flange (at PP77). The Heat Straightening was performed according to Heat Straightening Request (HSR) no: HSR1(B)-8722 Rev-0, Dated: 07/02/10. The ZPMC QC is identified as Zhang Qiang. HSR was performed to correct the weld distortion on the Floor Beam Flange. See attached photo for further details.

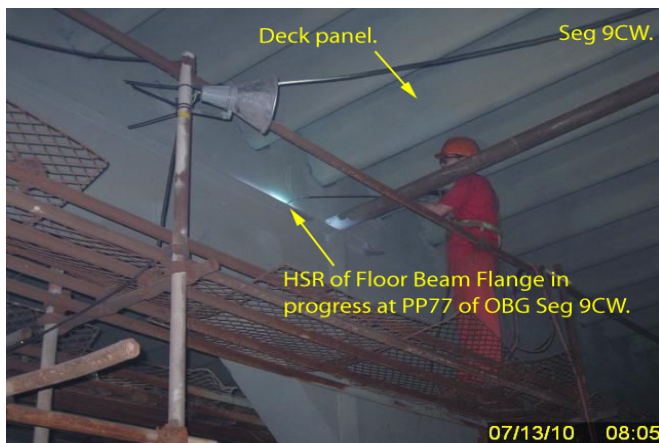
Bay 5:

Notification no: 006189.

This QA inspector performed Magnetic Particle Testing (MPT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector generated an MPT report for this date. The member(s) are identified as OBG component – Traveler Rail. The weld designations reviewed were as follows:

- 1) 10TR2-012-005, 006, 007, 013 & 014.
- 2) 10TR1-013-005, 006, 007, 013 & 014.
- 3) 11TR3-016-005, 006, 007, 013 & 014.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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